

Work Order ID 58986

May 20, 2010 2:27:23 PM



Page 1

Item ID: D3969-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring (Basket Lid)

Start Date: 5/20/10 Start Qty: 12.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: CZ

Date: 10/5/20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3969	C

100 0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 11950
Order as per Dwg D3969
Possible supplier: LS Technologies
part#: SSA4/8-122-310-360N
Material release note is required

CZ 10/5/20 (12)

110 0.00



Packaging

Memo

0.00

Packaging

Receive & Inspect for Damage & Mat'l Certs

Pc/4/6/3 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58986

May 20, 2010 2:27:23 PM



Page 2

Item ID: D3969-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spring (Basket Lid)

Start Date: 5/20/10 Start Qty: 12.00



Cust Item ID:

Required Date: 5/27/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00



QC

yes for 83 lbs
Memo

0.00

Quality Control

5/26/10

(X12)

130

Identify as per dwg & Stock Location: 272

0.00



Packaging

Memo

0.00

Packaging

10-6-4 SP 12x

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07
ME
10-6-7

May 20, 2010 2:27:22 PM

1. Name of the company	2. Name of the person
3. Address	4. Address
5. City	6. City
7. State	8. State
9. Zip	10. Zip
11. Phone	12. Phone
13. Fax	14. Fax
15. E-mail	16. E-mail
17. Website	18. Website
19. Other	20. Other
21. Other	22. Other
23. Other	24. Other
25. Other	26. Other
27. Other	28. Other
29. Other	30. Other
31. Other	32. Other
33. Other	34. Other
35. Other	36. Other
37. Other	38. Other
39. Other	40. Other
41. Other	42. Other
43. Other	44. Other
45. Other	46. Other
47. Other	48. Other
49. Other	50. Other
51. Other	52. Other
53. Other	54. Other
55. Other	56. Other
57. Other	58. Other
59. Other	60. Other
61. Other	62. Other
63. Other	64. Other
65. Other	66. Other
67. Other	68. Other
69. Other	70. Other
71. Other	72. Other
73. Other	74. Other
75. Other	76. Other
77. Other	78. Other
79. Other	80. Other
81. Other	82. Other
83. Other	84. Other
85. Other	86. Other
87. Other	88. Other
89. Other	90. Other
91. Other	92. Other
93. Other	94. Other
95. Other	96. Other
97. Other	98. Other
99. Other	100. Other

[illegible]

Required Date: 5/27/10

Required Qty: 12.00

A standard linear barcode consisting of vertical black bars of varying widths on a white background.

Gas Spring

[REDACTED]

Pc 10/6/

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

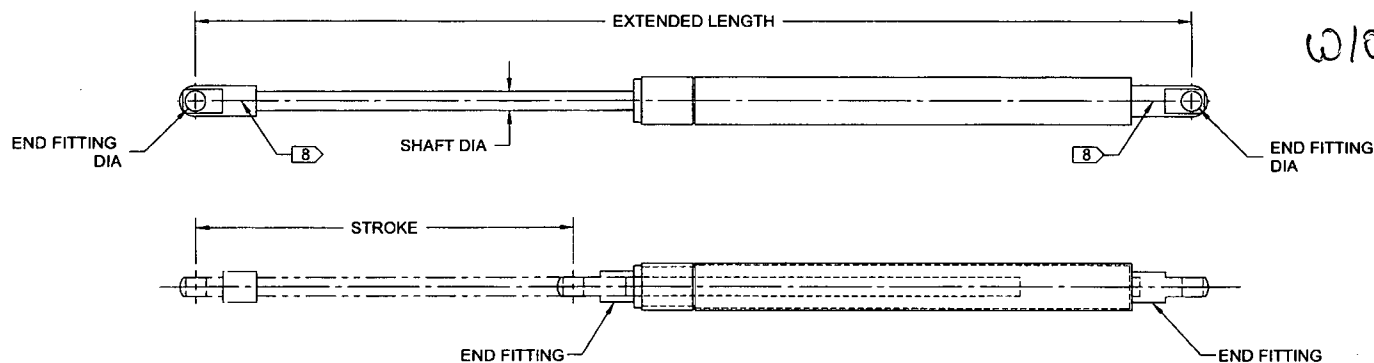
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

CL10/5/20
W10' 58967



D3969-X SPRING

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	120/4.70	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	120/4.70	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	120/4.70	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs

RELEASED
2010-03-12
MD

- NOTES:**
- 1) MATERIAL: SEE CHART
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: SEE CHART
 - 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

REV.	DESCRIPTION	BY	DATE
C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	N/A	D3969	SHEET 1 OF 1
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BASKET LID SPRING	NTS
DATE	10.03.04	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

18 Units: SSA4/8-122-310-360N (D3969-3) Stainless Gas Spring

Country of Manufacture: Canada

Date of Manufacture : June 2010

This product is ROHS compliant.

121.0 11980

5/10/64/68

We certify no mercury was used in the manufacture of this order.

Purchase Order #11950

Invoice # 6171

L S Technologies Inc Canada

A stylized, handwritten signature in black ink, consisting of a large, sweeping loop followed by a horizontal line.

Nolan Fehr
Manager